

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015475**Date Inspected:** 04-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW tack welding of weld joint SSD1-TL5-1B/F-26A located on PCMK north tower, lift 5, outside stiffener. Welder was identified as 057186. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Lu Wei Chao, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-3213-TC-U4. An arc strike was observed in the lift 5 skin approximately 250mm from a tack weld. Also present at this location and appearing to monitor the welding operation was ABF Representative Cui Zhenghua. This QA Inspector marked the arc strike to be ground and magnetic particle tested, and reported this to ZPMC QC Lu Wei Chao and ABF Representative Cui Zhenghua. See photos below.

SMAW tack welding of weld joint SSD1-TL5-1B/F-53 located on PCMK north tower, lift 5, inside stiffener. Welder was identified as 052930. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Lu Wei Chao, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-3113. Also present at this location and appearing to monitor the welding operation was ABF Representative Cui Zhenghua.

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## WELDING INSPECTION REPORT

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### Bay 11

This QA Inspector randomly observed no welding related work being performed in Bay 11.

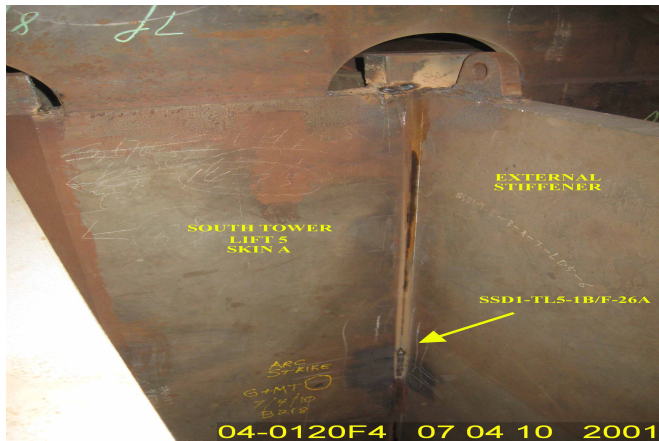
### OBG Trial Assembly Area

This QA Inspector randomly observed no work being performed in the OBG Trial Assembly Area. ZPMC CWI Li Yang acknowledged that no work was being performed in the Trial Assembly Area.

### Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 and 3 were erect, respectively. The worker access elevator was dark and no ZPMC workers were present. ABF Representative Li Xiu Hua acknowledged that no work was being performed on the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Dawson, Paul

QA Reviewer